

Work Order ID 125848

125848

Page 1

Wednesday, October 22, 2014 12:37:05 PM

Item ID: D3650-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Center Panel

Start Date: 10/21/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLO

Date: 10-23 Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool HD

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3650	Rev E

100

100
Waterjet

FLOW CNC Waterjet

304.06
0.040

FLOW WATER JET

Memo

1-Cut as per Dwg D3650
Dwg Rev: G
Prog Rev: E

2-Deburr if necessary

110

110
QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

① 10/14/02

① 10/17/02

SCRAP

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering
	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other
Suspected Unapproved			Large Fab		Composite			Supplier	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General								
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

Work Order ID 125848

Wednesday, October 22, 2014 12:37:05 PM

125848

Page 2

Item ID:	D3650-3	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Center Panel						
Start Date:	10/21/14	Start Qty: 1.00	*1*	Cust Item ID:			
Required Date:	10/21/14	Req'd Qty: 1.00	*1*	Customer:			
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00							38 9-89
	Memo	0.00							NOV 03 2014
130 *130* Brake NC Brake NC	NC BRAKE	0.00							DAS 30 9-89
	Memo	0.00							14/10/20 PTO
	1-Form as per Dwg D3650 using DT9426								
	2-bend as per dwg								
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: <u>125 848</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3650-7</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. <u></u>							

FAULT CATEGORY

Landing Gear	General	General	General	General
<input type="checkbox"/> Bending	<input checked="" type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		
			<input type="checkbox"/> Other	

Work Order ID 125848***125848***

Page 3

Wednesday, October 22, 2014 12:37:05 PM

Item ID: D3650-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Center Panel

Stop

NS2

Start Date: 10/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location:

0.00

190

Packaging

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Quality Control

Memo

0.00

~~00~~
Scrapped
10/21/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions, Pressure/Forced						
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance Set-up						
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect Temperature/Cure						
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing Weld						
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved Wrong Stock Pulled						
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong Power Loss/Surge						
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Other						
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Picklist Print

Page 1

Wednesday, October 22, 2014 12:37:04 PM

Work Order ID: 125848

125848
D3650-3

Parent Item: D3650-3

Parent Item Name: Center Panel

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC

IPP Rev:B ECN 1113P 08-01-22 DD IPP REV:C

AS PER REV E 12-10-09 JLM VERIFIED BY:DD

IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No			sf	161.6939		2			**

M304S20GA

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	161.6938948	
m126852	0.31	
m127454	26.1018948	
m128435	81.14	
m129845	28.89	
m130345	25.252	1.8655

10/11/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: Part No. NCR No.	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend			
Centre Not Concentric	BOM/Route			
Cracks	Broken/Damage/Defect			
Crimp/Kink/Ripple/Wave	Burrs			
Cuffs	Contamination			
Crushing	Countersink			
Heat Treat	Cut Too Short			
Inspection Strip in Tube	Drawing			
Marks/Chatter	Drill Holes			
Turning Sequence	Finish			
Wave/Twist in Tube	Fit/Function			
	Folio/Program			
	Grain			
	Hardware			
	Inspection Incomplete/Unqualified			
	Instructions Incomplete/Unclear			
	Misaligned/off center			
	Mislabeled			
	Misread			
	Off-set			
	Out of Calibration			
	Out of Sequence			

DART AEROSPACE LTD	Work Order:	125848
Description: Center Panel	Part Number:	D3650-3
Inspection Dwg: D3650 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

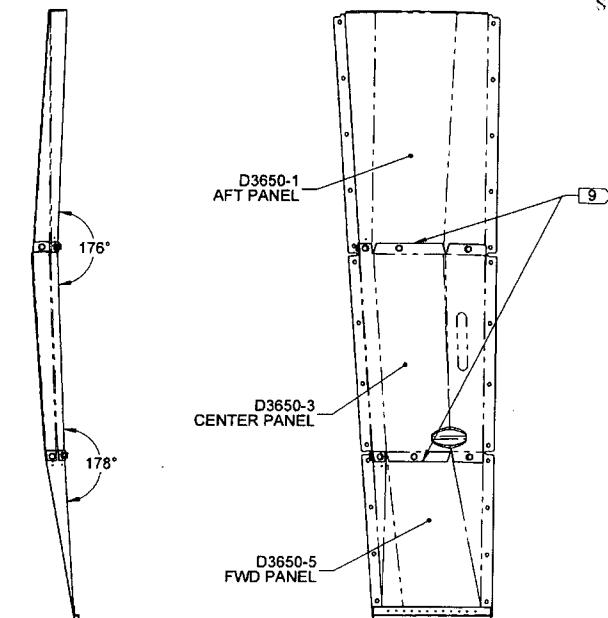
10

Measured by: <u>D</u>	Audited by: <u>38</u> <u>9.80</u>	Preliminary Approval:
Date: <u>17/11/02</u>	Date: <u>NOV 03 2014</u>	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	
B	12.03.08	Dwg Rev updated	KJ	
C	12.09.26	Dimensions updated per Dwg Rev D	KJ	
D	12.10.26	Dimensions updated per Dwg Rev E	KJ	

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

E

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.3 lbs
- 8) TORQUE FASTENERS 15 TO 25 in-lb
- 9) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

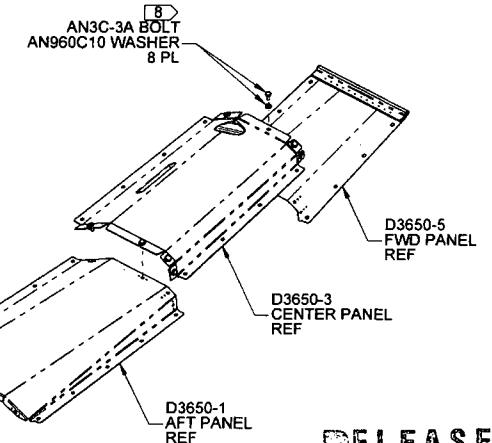
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 125848 MLS

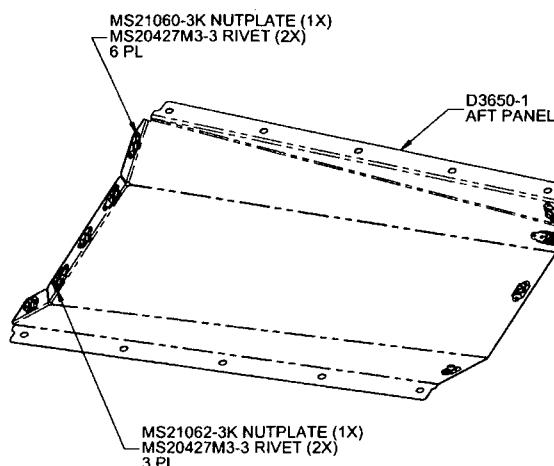
1410-23



RELEASED
2012-10-09
AM

E	REVISED D3650-3: 0.040 IN THICKNESS WAS 0.018. MINOR DIMENSIONAL CHANGES AS A RESULT.	MB	12.10.01
D	D3650-11 REPLACED WITH AN EMBOSSED PAGE 4. DELETED. D3650-3 BEND RELIEFS CHANGED TO TRIANGULAR SHAPE AT BOTH ENDS. D3650-3 HOLES CHANGED TO SLOTS. ALL NOTES UPDATED TO CONFORM TO QSI 048. TIGHTENED CUT TOLERANCES IN ALL FLAT PATTERNS. DELETED D3650-C-1 INCORPORATED.	RP	12.08.12
C	REFORMATTED TO NEW STANDARDS; RELOCATED SECTION 1 (DRAFT) & ADDED SECTION VIEW 10; REVISE DIMENSIONS (ZN D7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN D6-5, D5-5); MS20615-AM5 WAS CR3522-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7, B5-7, BB-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 6: REMOVED/RELOCATED HOLES; UPDATED SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE B; SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED SECTION 3-5; MOVED D3650-11-11F TO SHEET 9; ADDED DETAIL 1; SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6; UPDATED DIMS OF D3650-11-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKSBURY, ONTARIO, CANADA	
CHECKED	<i>SP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>SP</i>	D3650	SHEET 1 OF 8
APPROVED	<i>SP</i>	TITLE	SCALE
DE APPR.	<i>SP</i>	TOP PANEL ASSEMBLY	NTS
DATE	12.10.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

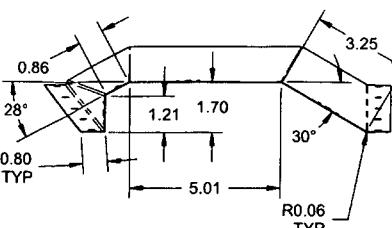
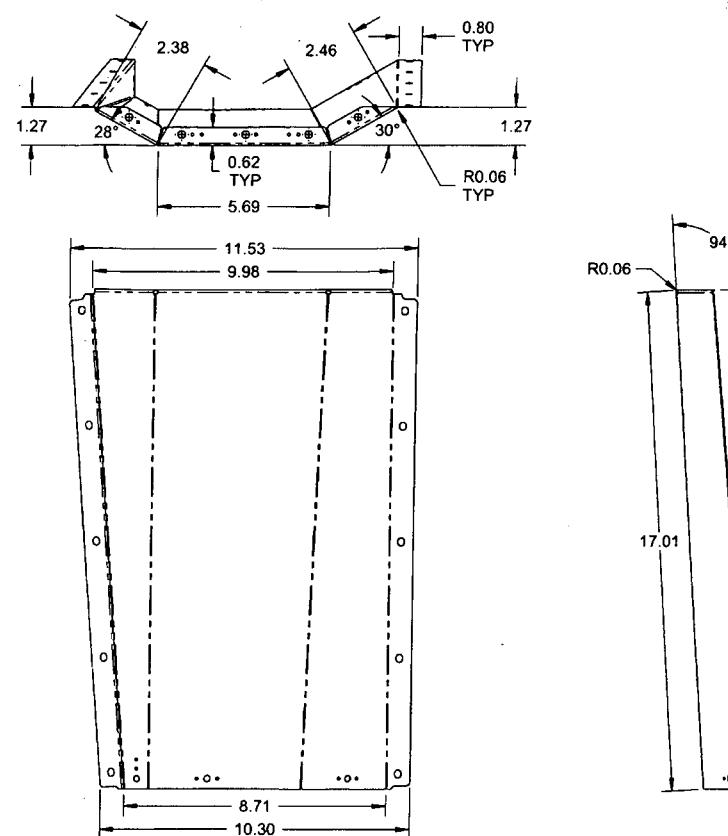
QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUTPLATE



D3650-1 AFT PANEL

NOTES:

- 1) MATERIAL: MAKE FROM D3650-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.3 lbs

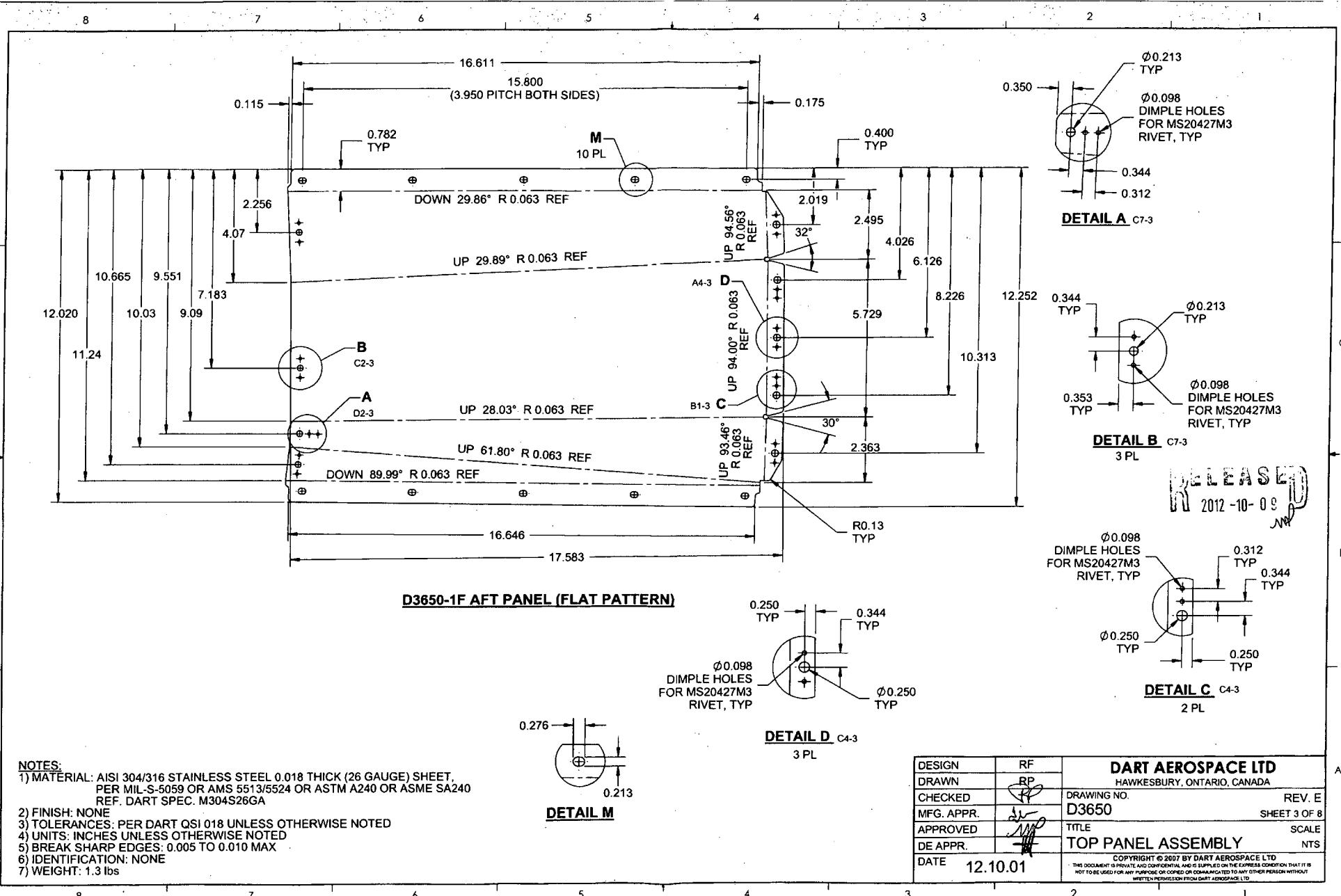


D3650-1B AFT PANEL BENT PART

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RP</i>	DRAWING NO. REV. E	
MFG. APPR.	<i>RP</i>	D3650 SHEET 2 OF 8	
APPROVED	<i>RP</i>	TITLE	
DE APPR.	<i>RP</i>	SCALE	
DATE 12.10.01		NTS	

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8

7

6

5

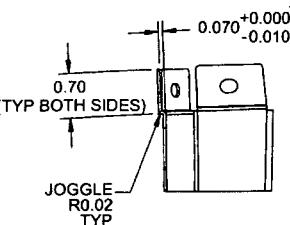
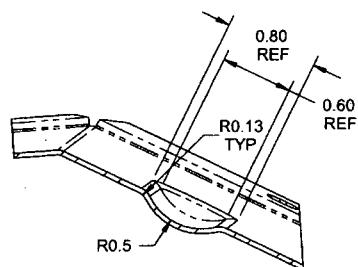
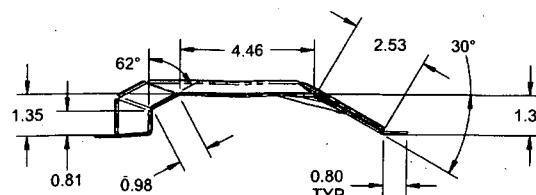
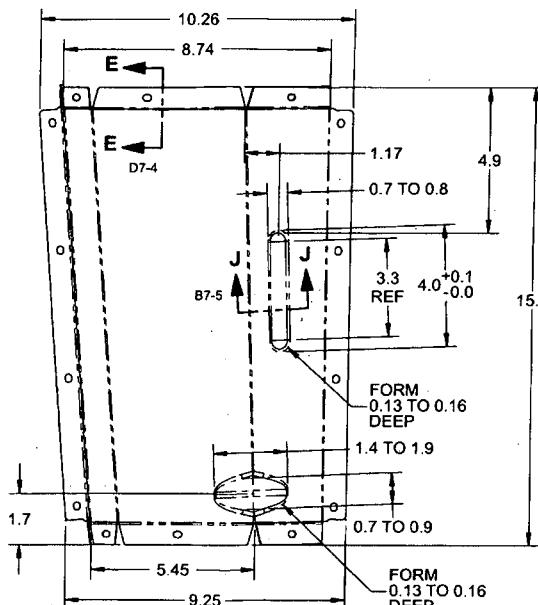
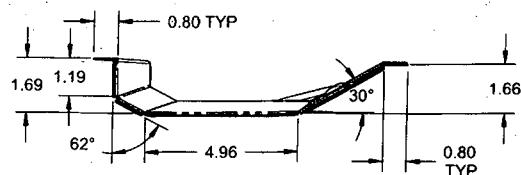
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3

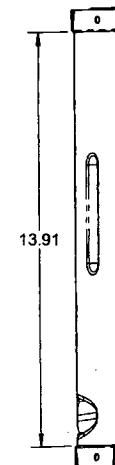
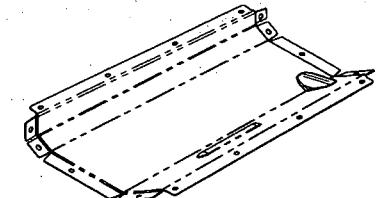
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1

D

**SECTION E-E** C5-4**SECTION J-J** C4-4**E D3650-3 CENTER PANEL**

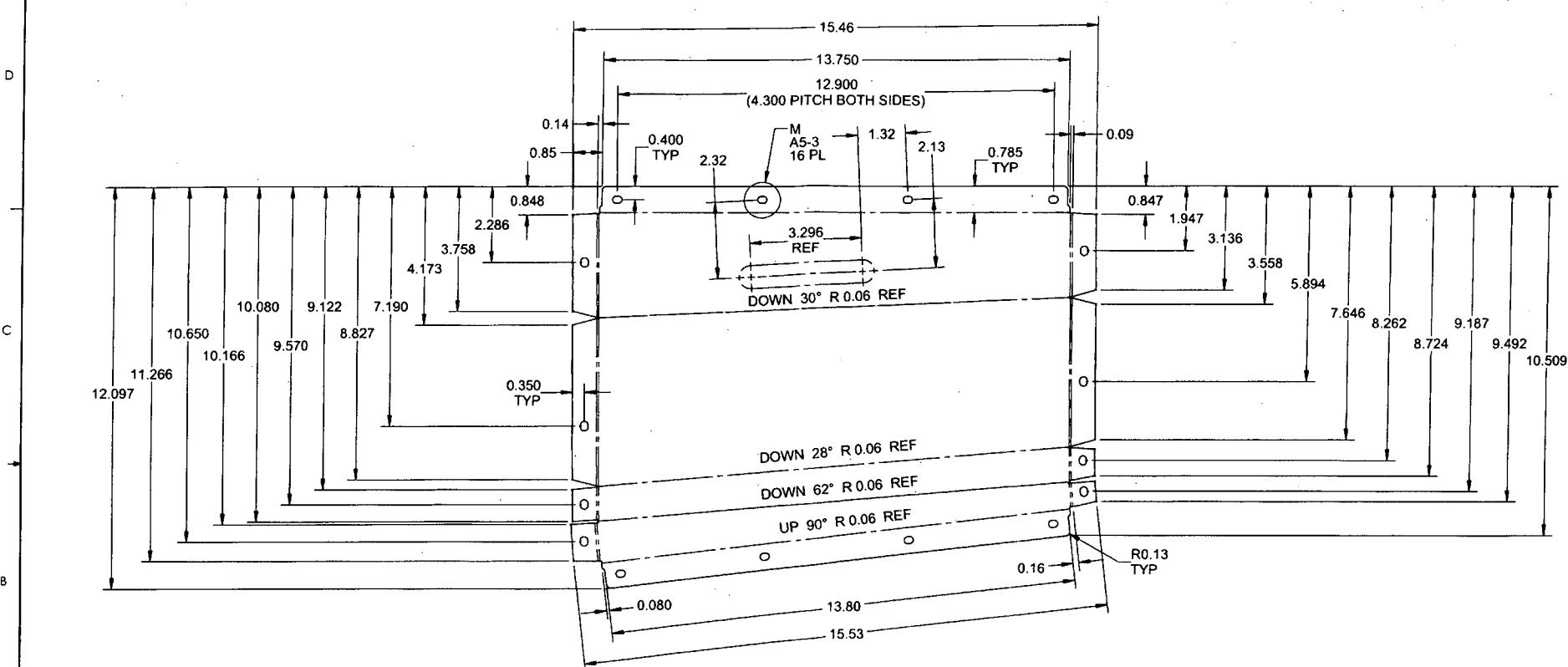
NOTES:
 1) MATERIAL: MAKE FROM D3650-3F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.98 lbs



RELEASED
2012-10-09

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3650	
APPROVED		REV. E	
DE APPR.		SHEET 4 OF 8	
DATE 12.10.01		TITLE	TOP PANEL ASSEMBLY NTS
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8 7 6 5 4 3 2 1

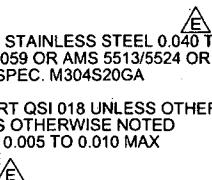


A D3650-3F CENTER PANEL (FLAT PATTERN)

RELEASED
2012-10-09
JW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.040 THICK (20 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.98 lbs



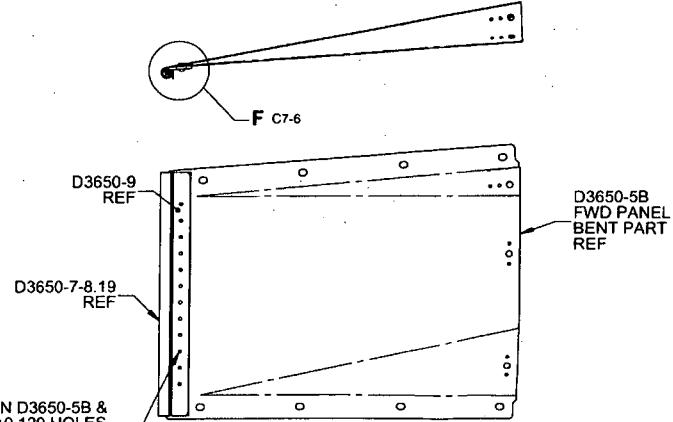
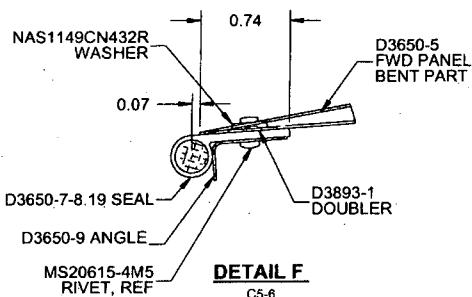
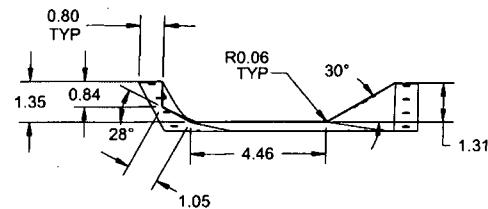
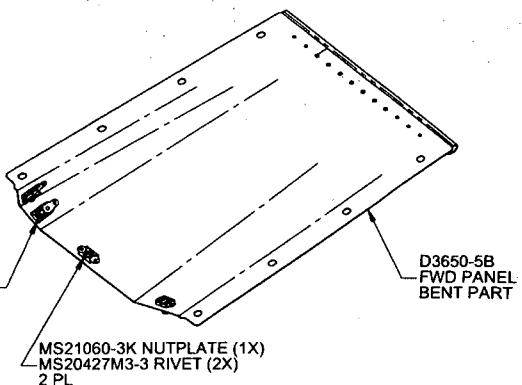
DESIGN	RF	DART AEROSPACE LTD
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3650
MFG. APPR.	SDP	REV. E
APPROVED	JW	SHEET 5 OF 8
DE APPR.	JW	TITLE: TOP PANEL ASSEMBLY
DATE	12.10.01	SCALE: NTS

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8 7 6 5 4 3 2 1

A

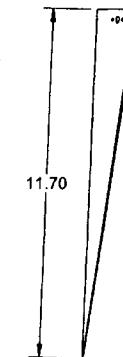
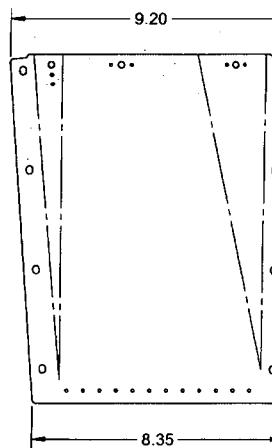
QTY	PART NUMBER	DESCRIPTION
5	X. D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
1	D3893-1	DOUBLER
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE



D3650-5 FWD PANEL

NOTES:

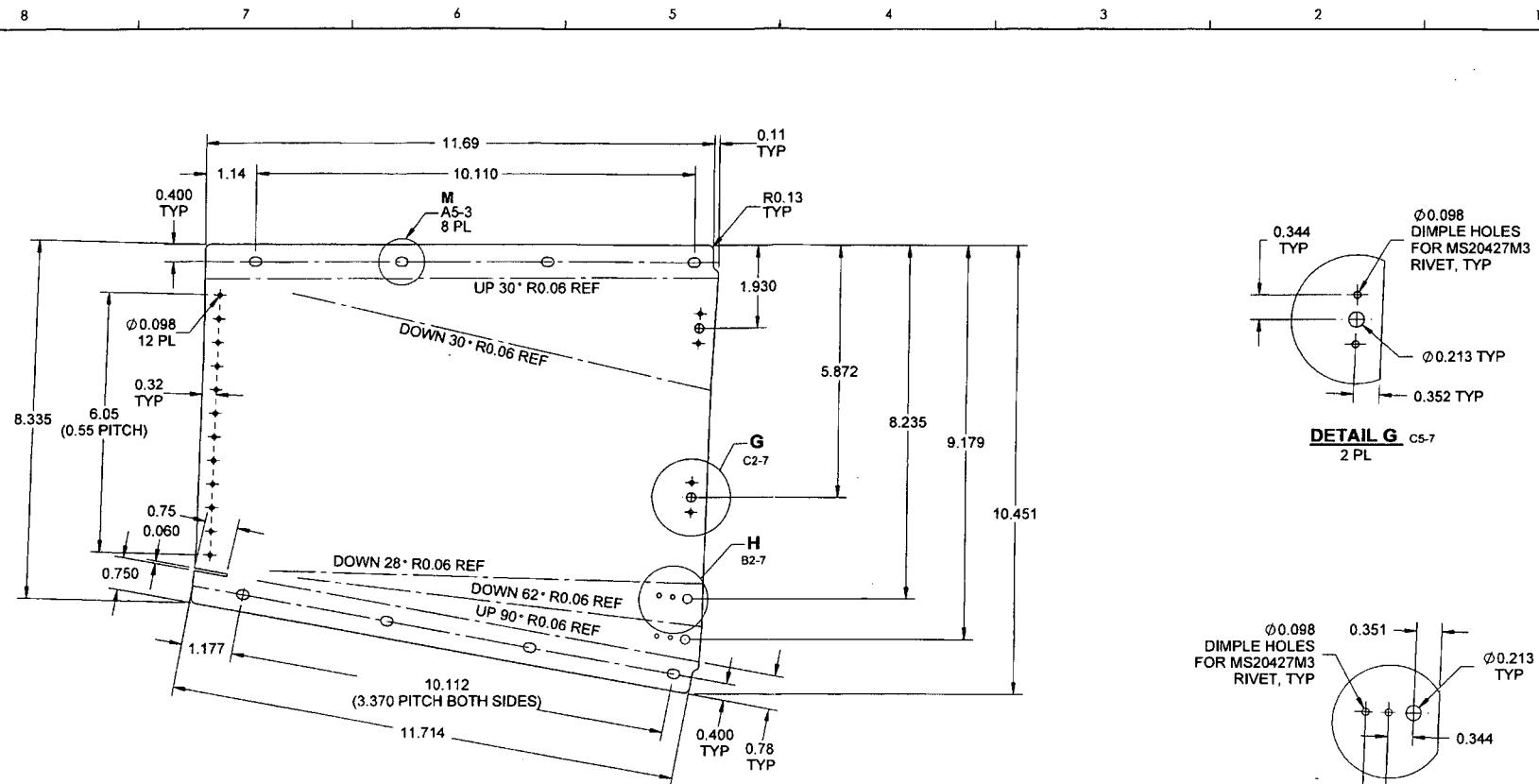
- 1) MATERIAL: MAKE FROM D3650-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs.



D3650-5B FWD PANEL BENT PART

RELEASED
2012-10-09
W

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RR	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ST	DRAWING NO.	REV. E
MFG. APPR.	AL	D3650	SHEET 6 OF 8
APPROVED	JAD	TITLE	SCALE
DE APPR.	W	TOP PANEL ASSEMBLY NTS	
DATE	12.10.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3650-5F FWD PANEL (FLAT PATTERN)

NOTES:

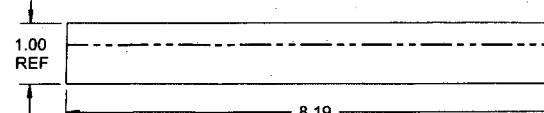
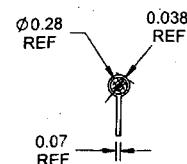
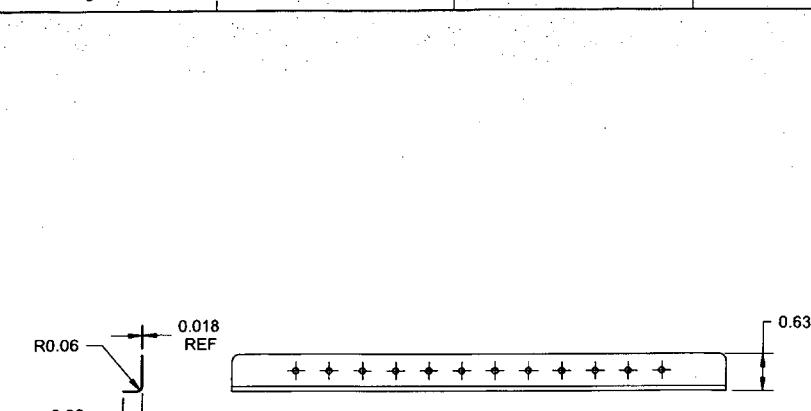
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. E	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.	D3650
APPROVED	<i>[Signature]</i>	SHEET 7 OF 8	
DE APPR.	<i>[Signature]</i>	TITLE	TOP PANEL ASSEMBLY
DATE	12.10.01	SCALE	NTS

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RELEASE
2012-10-02
AND

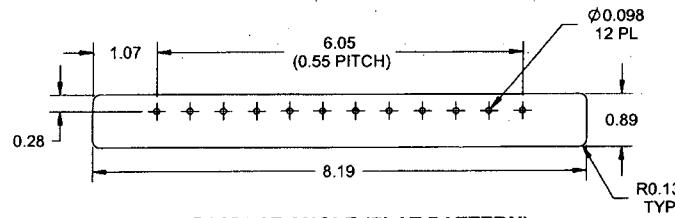
8 7 6 5 4 3 2 1



D3650-7-8.19 SEAL

NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-XX
WHERE XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50



D3650-9F ANGLE (FLAT PATTERN)

D3650-9F

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. E	
MFG. APPR.	<i>[Signature]</i>	D3650	
APPROVED	<i>[Signature]</i>	SHEET 8 OF 8	
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE 12.10.01		NTS	

TOP PANEL ASSEMBLY

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2012-10-09
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